










Work Order ID 64631

Thursday, December 09, 2010 1:06:38 PM

Page 1

Item ID:	D2512	Accept		Setup	Start	
Revision ID:						
Item Name:	Basket Lid 205/350				Stop	
Start Date:	12/9/2010	Start Qty:	1.00		Cust Item ID:	
Required Date:	12/16/2010	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>PL</u>	Date:	<u>10-12-9</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2512	Rev E								
100	Weld per dwg A/R S.S. rod Batch: <u>11585</u>	0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Cut 3/4" x 3/4" square tubing as per Dwg D2512								
	2-Cut (4) D2236 From D3166-3								
	3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305								
	4-Weld as per Dwg D2512 using Welding Jig DT 9436								
	Deburr as required								
	INSTALL D2012-117 CLEVIS ONLY ON D130-701-041								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	QC								
Quality Control	Memo	0.00							

① PL 10-12-21

BE
10-12-22

1 φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00							
Quality Control									
125	Pressure Wash per QSI005 4.3	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

1 BR 10-12-22

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	


Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
									
Powdercoat									
Powder Coating									

Memo
1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat

M115951.
1ST COAT:
START TIME: 1:30
OVEN TEMPERATURE: 400
FINISH TIME: 2:00

2ND COAT:
START TIME:
OVEN TEMPERATURE:
FINISH TIME:

140	HandFinishing	0.00							
									
HandFinish									
Hand Finishing									

Memo
✓ Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4
Batch: M115790 SPRAY PAINT: M116123

21 10/12/23

1 BL 10-12-22

1 0

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Item ID: D2512

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Lid 205/350

Start Date: 12/9/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 12/16/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8/11/01/03

(x1)

160

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

w/o 64628 => 11/01/03 1 0
D350-607-01

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/01/03

u 11.01.03

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Picklist Print

Thursday, December 09, 2010 1:06:50 PM

Page 1

Work Order ID: 64631

Parent Item: D2512

Parent Item Name: Basket Lid 205/350



Start Date: 12/9/2010

Required Date: 12/16/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: Rev IPP:M03.01.31 AddedD2012-117forD130-701-041□KJ/RF
 IPP Rev:N□06.04.05 Added level21 EC
 IPP REV:O ADDED D3490-1/-3 FOR D130-701-011/-043 10-04-20 JLM
 VERIFIED BY:DD
 IPP Rev:P 08-08-29 revE as per dwg DD verified by:EC
 IPP Rev:Q 08-09-24 plug holes prior to powder coating DD verified
 by:EC IPP Rev:R 10.06.29
 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2012-117 Clevis		Manufactured	No			100	Each	28.0000	2	2			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> <div> <div>WA</div> <div>28</div> <div></div> </div> <div> <div>3091</div> <div>1</div> <div></div> </div> <div> <div>55729</div> <div>27</div> <div></div> </div>													
*** ONLY APPLICABLE ON D130-701-041 -IF NOT USED, PLEASE MARK N/A ***													
D2232-1 Basket Hinge		Manufactured	No			100	Each	16.0000	2	2			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> <div> <div>WA</div> <div>16</div> <div></div> </div> <div> <div>55791</div> <div>16</div> <div></div> </div>													
D2327-1 Spacer Bushing		Manufactured	No			100	Each	15.0000	2	2			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> <div> <div>WA</div> <div>15</div> <div></div> </div> <div> <div>54658</div> <div>3</div> <div></div> </div> <div> <div>60174</div> <div>12</div> <div></div> </div>													

M/S

Pl 10.12.21

2

Pl 10.12.21

10

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Page 2

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Parent Item: D2512

Parent Item Name: Basket Lid 205/350

Start Date: 12/9/2010

Required Date: 12/16/2010

Start Qty: 1.00

Required Qty: 1.00

D2506

Manufactured No

100 Each

4.0000

1

1



Label Plate



Pl 10.12.21

Location

Loc Qty

Loc Code

WA

4

63254

4

D2581

Manufactured No

100 Each

13.0000

2

2



Mounting Bracket



Pl 10.12.21

Location

Loc Qty

Loc Code

WA

13

61953

13

D3166-3

Manufactured No

100 Each

10.3281

1

1



Basket Hoop



364425 - 2

SAD 10-12-17

Location

Loc Qty

Loc Code

WA

10.32807105

55697

2.1053E-05

59266

0.0418

60270

0.00265

61193

0.0416

63063

4.242

64244

6

2

Thursday, December 09, 2010 1:06:51 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Thursday, December 09, 2010 1:06:51 PM

Page 3

Work Order ID: 64631

Parent Item: D2512

Parent Item Name: Basket Lid 205/350



Start Date: 12/9/2010

Required Date: 12/16/2010

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F

Purchased

No

100

sf

864.2619

18

18.94737



Expanded Metal Flat SS



SAD 10-12-17

Location

Loc Qty

Loc Code

MAT

864.261933

114809

78.622943

114853

11.80059

115012

393.8315

115067

13.0125

115171

6.0394

115401

72.0095

115665

5.6216

115989

46.5313

116178

236.7926

18.9474

M304TS0.750W.065

Purchased

No

100

f

983.7806

43.5804

45.87411



304 SQ Tube .75x.75x.065W



SAD 10-12-17

Location

Loc Qty

Loc Code

MAT

983.7806

112398

0

116267

983.7806

45.8742

Thursday, December 09, 2010 1:06:51 PM

Shop Packet Print

Page 3

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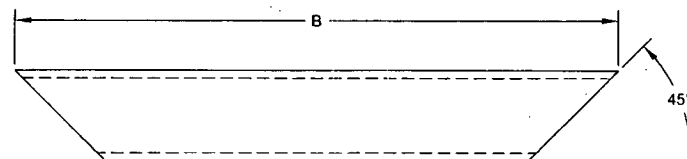
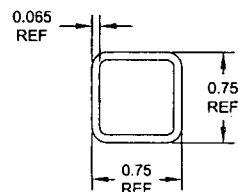
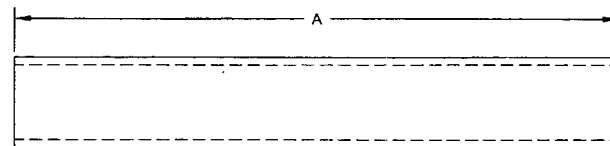
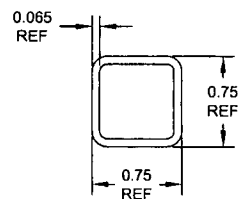
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PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 64631
BS 10-12-9



RELEASED
08.06.17

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPADTED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS. INCORP DEO 8074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS REPRODUCED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

D2512-1/-3/-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

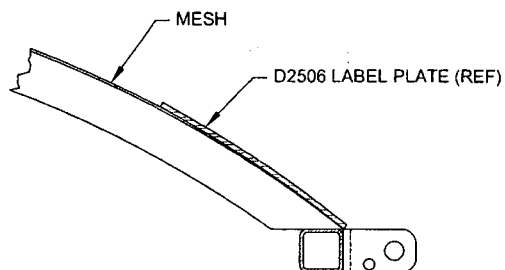
W/O:		WORK ORDER CHANGES					
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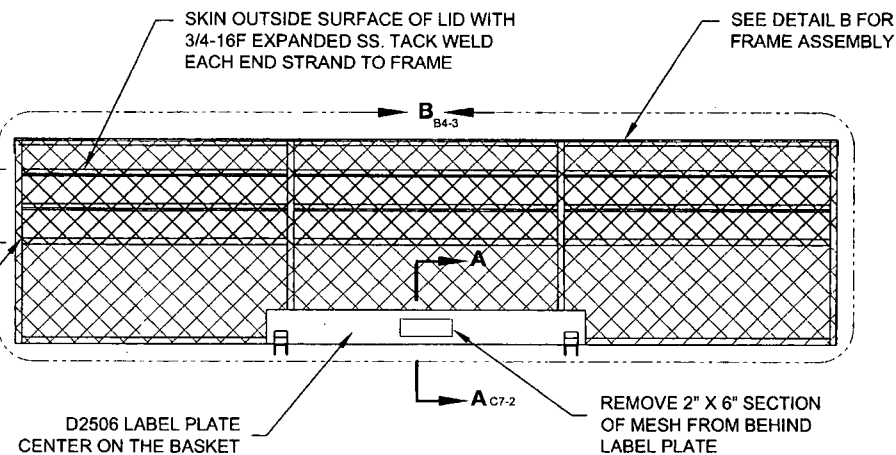
NOTE: Date & initial all entries



SECTION A-A_{B3-2}
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.

TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKIDDED



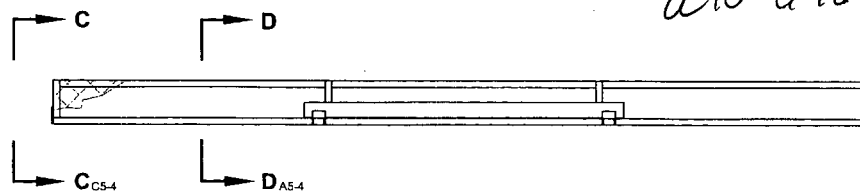
D2506 LABEL PLATE
CENTER ON THE BASKET

REMOVE 2" X 6" SECTION
OF MESH FROM BEHIND
LABEL PLATE



D2512 BASKET LID ASSEMBLY NOTES:

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004



RELEASED
08.06.17

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

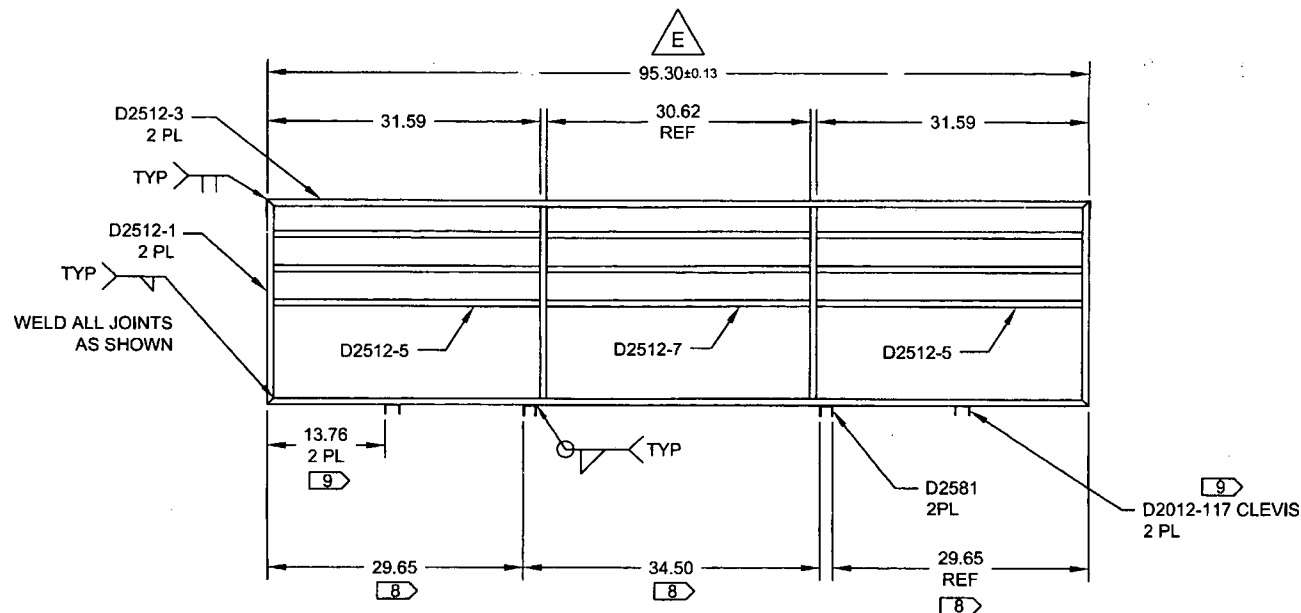
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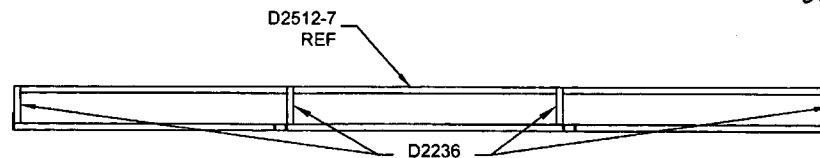
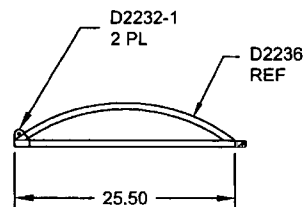
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DETAIL B C3-2
FRAMEWORK ONLY SHOWN FOR CLARITY



NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY
- 9) FOR D130-701-041 ONLY

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J	DRAWING NO.	REV. E
MFG. APPR.	JS	D2512	SHEET 3 OF 4
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BASKET LID ASSEMBLY (350/212)	NTS
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RELEASED
08-06-21/17

w/b 64631

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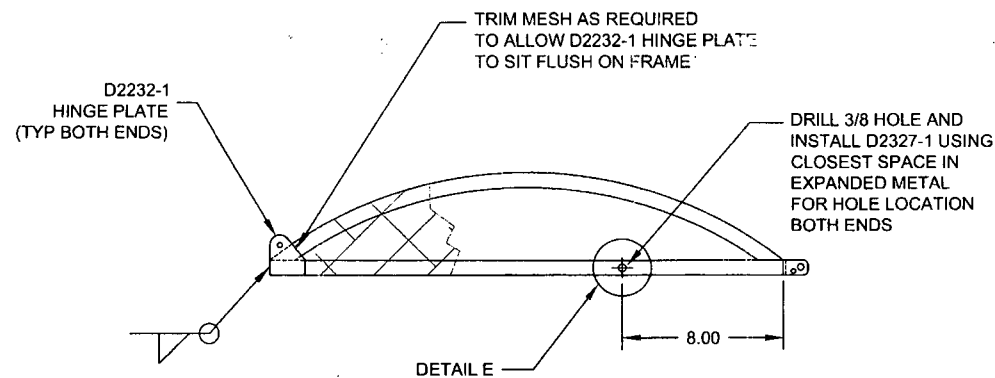
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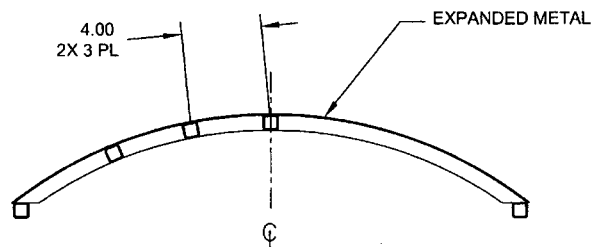
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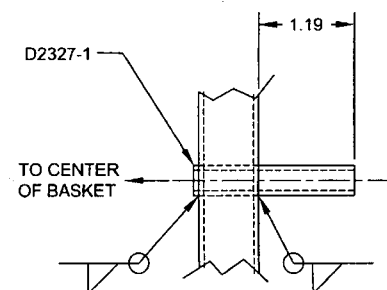
8 7 6 5 4 3 2 1



VIEW C-C SIMILAR BOTH END RIBS A5-2



SECTION D-D SAME BOTH CENTER RIBS A4-2



DETAIL E C6-4

W/O 64431

RELEASED
08-06-21/17

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. ARTS IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries